

Work Order ID 70827

Wednesday, June 15, 2011 2:41:06 PM

Page 1

Item ID: D2651-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Plug

Start Date: 6/15/2011 Start Qty: 30.00

Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 30.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2651

Rev B

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1- Turn as per Folio FA219 and Dwg D2651-2- Deburr

SA 11/6/15

30 ✓

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SA 11/6/15

30 ✓

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

PR 11-6-16

30 ✓

Work Order ID 70827

Wednesday, June 15, 2011 2:41:06 PM



Page 2

Item ID: D2651-1

Accept



Setup Start



Revision ID:

Item Name: Plug

Stop



Start Date: 6/15/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr ias per dwg D2651

Handwritten: 4/56/15

Handwritten: 30

Handwritten: 4

140

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

Handwritten: 25 11-06-16 (x30)

155

0.00



SprayPaint

Memo

0.00

Spray Painting

Handwritten: PRIME B 117319
SPRAY PAINT DELFLEET BLUE B 115985
CLEAR DELFLEET B 117984

Handwritten: 25 11 06-16 (x30)

Work Order ID 70827

Wednesday, June 15, 2011 2:41:06 PM



Page 3

Item ID: D2651-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plug

Start Date: 6/15/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

156 QC14- Inspect Spray Paint

0.00



QC Memo

0.00

Quality Control

11 06 17

170 Identify as per dwg & Stock Location: FP-A

0.00



Packaging Memo

0.00

Packaging

30x 11/06/17

180 QC21- Final Inspection - Work Order Release

0.00



QC Memo

0.00

Quality Control

11/6/20

ME 11-06-17

Picklist Print

Wednesday, June 15, 2011 2:41:04 PM

Page 1

Work Order ID: 70827

Parent Item: D2651-1

Parent Item Name: Plug



Start Date: 6/15/2011

Required Date: 6/17/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP: A 02.04.15 New Issue NG
IPP: B 05.12.12 added deburr EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6R0.500

Purchased

No

100

f

85.0050

0.0401

1.266316



6061-T6 Round Bar .500"

SA 6/16/15

Location

Loc Qty

Loc Code

MAT012

85.005

114488

4.605

117379

80.4

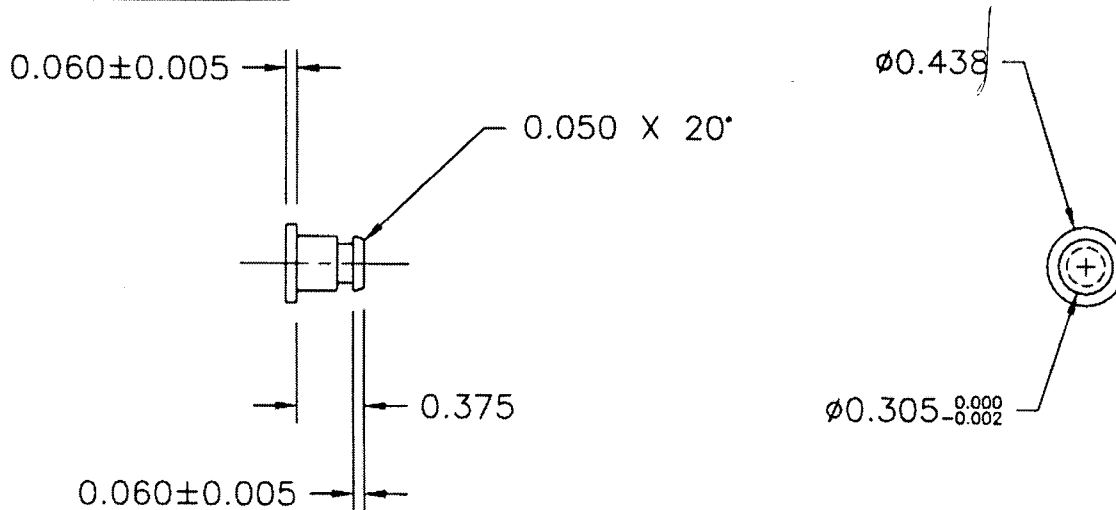
1-4 At



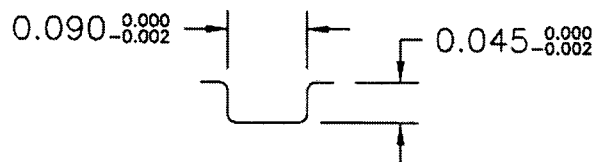
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

RELEASED
03.12.19 #

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



u/b 70827

D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

Copyright © 1997 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.